

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000431**Date Inspected:** 06-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China

Witness: **Procedure Qualification Record**
 Welding **NDT**

Welder Qualification
Mechanical Testing, describe:

Fracture Critical**Index Lot #:** B72-054-07a**Witness Lot #:** B71-051-07**Bridge No:** 34-0006**Component:** Bid:52**Welder:** Jiang Xie Hu**ID #:** N/A**Joint Description:** B-U2-S

N/A

WPS ID #: PWPS-B-T-3221

N/A

Base Metal: HPS 485WT2/Z

N/A

PQR ID #: HP2007147-1

N/A

Thickness: 90 mm

N/A

Process: SAW

N/A

Electrode Spec/Class: AWS A5.23/ENi5

N/A

Positions: 1-G

N/A

Backing Material: A709M-HPS-485W

N/A

CWI: Huang Wei and Xu Bing

N/A

Average Amps:

N/A

AWS Code: D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector was present as requested to witness the mechanical tests for Procedure Qualification record(PQR) test plate using submerged arc welding(SAW) with 4.8 mm diameter electrode, in the 1G (flat) position. The test was performed per AWS D1.5, Section 5.20 requirements. The test results appeared to be in compliance with the contract documents.

Summary of Conversations:

The QA inspector did not have any relevant conversation regarding the PQR mechanical testing on this date.

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer